

Work Order ID 79965

79965

Page 1

Wednesday, February 08, 2012 10:08:38 AM

Item ID: D4575-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Beam

Start Date: 2/8/2012 Start Qty: 4.00

2

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 4.00

2

Customer:

Reference:

Approvals:

Process Plan: *mf*

Date: 12-02-08 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4575	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg								
2024 .050	Dwg Rev: <i>A</i>								
	Prog Rev: <i>A</i>								
	2-Deburr as required								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

12-2-21

(S)

12-2-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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2

Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

12 02 22 5

130

Bend as per dwg

0.00

130

Brake NC

NC BRAKE

Memo

0.00

Brake NC

Bend as per Dwg D3065

EB 12/02/22

5

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

12 02 23 5

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Required Date: 2/17/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

5 *QP/MA Feb. 23/2012*

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

5 *BR 12-2-23*

170

Identify as per dwg & Stock Location: *139F*

0.00

170

Packaging

Memo

0.00

Packaging

614/27 (5)

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 2/17/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00


180

QC

Memo

0.00

Quality Control

12/2/27 12-02-27
(5)

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Picklist Print

Wednesday, February 08, 2012 10:08:37 A

Page 1

Work Order ID: 79965

Parent Item: D4575-1

Parent Item Name: Beam

Start Date: 2/8/2012

Required Date: 2/17/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.12 NEW ISSUE DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.050		Purchased	No			100	sf	68.6000	0.553	1.1642105			

2024-T3 .050 sheet

1812-2-21

Location

Loc Qty

Loc Code

MAT022

68.6

117684

68.6

117684

5

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8 7 6 5 4 3 2 1

D

D

C

C

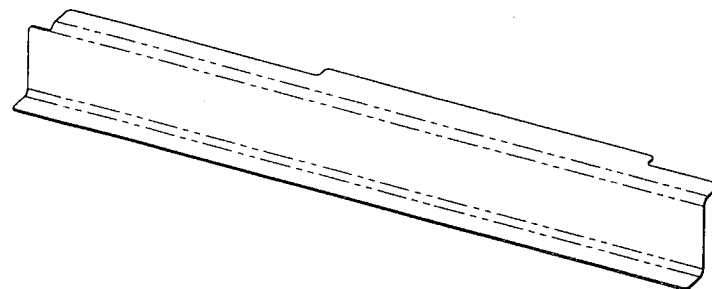
B

B

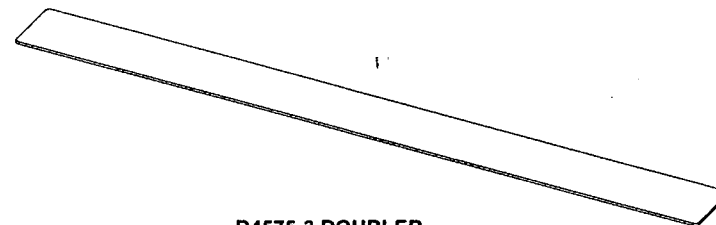
A

A

8 7 6 5 4 3 2 1



D4575-1 BEAM



D4575-3 DOUBLER

RELEASED
2012-01-12
MP

A	NEW ISSUE	MB	12.01.05
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.01.05		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4575	REV. A SHEET 1 OF 3
TITLE REINFORCEMENT	SCALE NTS
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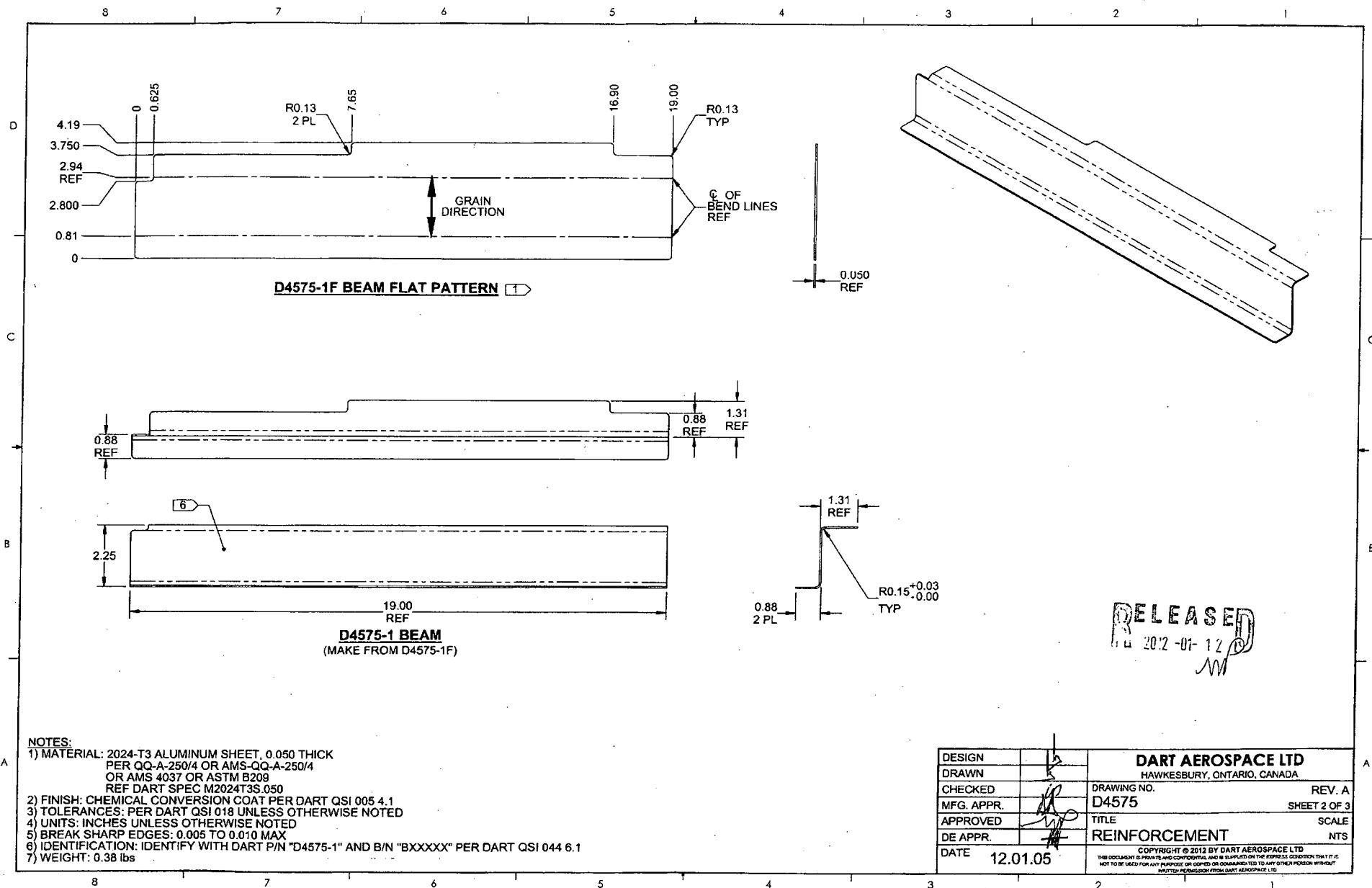
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Dart Aerospace Ltd

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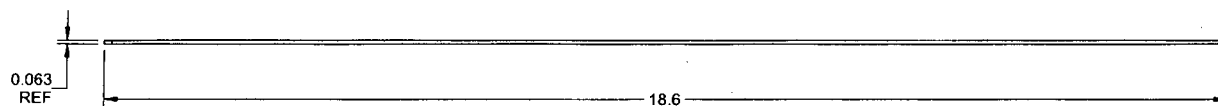
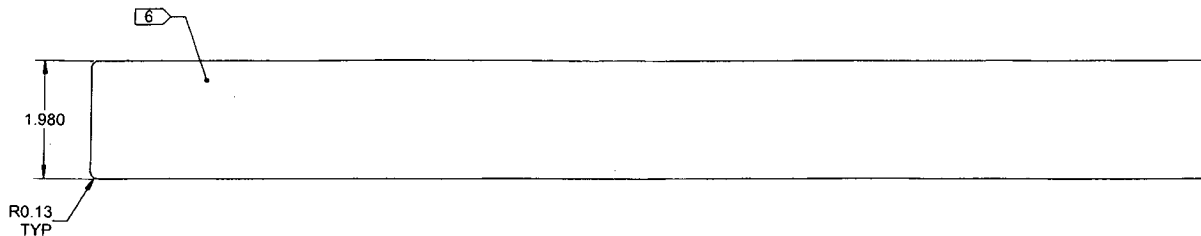
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8 7 6 5 4 3 2 1

D

D



D4575-3 DOUBLER

RELEASED
2012-01-12
MP

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/4 OR AMS-QQ-A-250/4
OR AMS 4037 OR ASTM B209
REF DART SPEC M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4575-3" AND B/N "BXXXXX" PER DART QSI 044 6.1
- 7) WEIGHT: 0.22 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4575	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		REINFORCEMENT	NTS
DATE	12.01.05	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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